

Split

Part Number	10255 - 1	Part Number	D2145
Alternate Number	101512	Drawing Number	D2646 REV C
U.I. Number	N/A	Project Number	N/A
Date Issue	6/16/2007	S.O. No.:	N/A
Next Rev	N/A	Type	PURCHASED PARTS
Initial Issue	N/A	Material	N/A
Previous Rev	31057	Due Date	6/5/2007
Entered By		Qty:	10
Entered & Approved By	<u>CH/07-05-16</u>	U.P.	None
Comments	Est. G 05/08/22 Hole size revised in Step 5 KJ/JLM Est Rev H Changed Item 101512 07-02-16 JLM		

Initial Configuration

Description

سی و یک

1500 es per l'any 1794.

Original photo now required

Gevestu

Copyright 2000 1,0000 Facts V100 - Total

16,000 Euros)

PACKAGING RESOURCE #1

CONTINUING EDUCATION RESPONSE

Please see the Insert for Teacher Resources.

For a Material Release Form, go to www.dhs.gov/inspectors-general

Dimensional check

Comments: UNAVERSIONAL CHECK

Inspect dimensions as per Dwg. D2543

SMALL & MEDIUM-BUSINESS

Compend. SMALL & MEDIUM EAR RESOURCE 1

3. Ref. using RTIS026 as per Dwg. D2645

2. Directly to 25°C, and directly per EN 60068-2-29.

2-Open holes to 250 mm. as per Dwg.

Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005.4.1

4/1

07-06-13

16

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

P/D: 4058 C207100127(2)

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0 QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

Insert

9.0 ALS71032130



Comment: Qty: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

INSERT

Batch: 11103418

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

4/1

07-07-04 - (2)

16

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

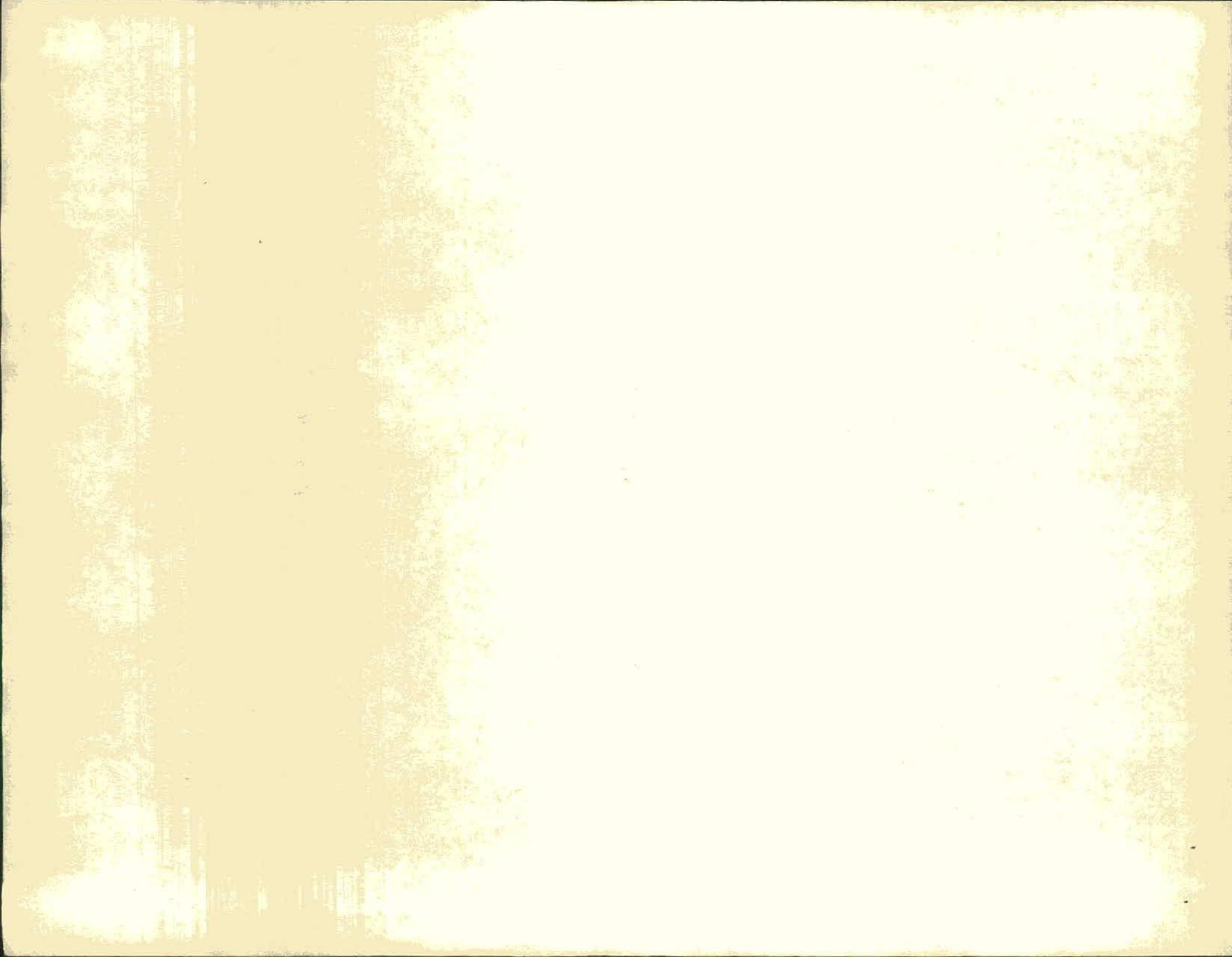
Identify and Stock

Location: _____

4/1

07-07-04 - (2)

16



Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation:

Description:

13.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

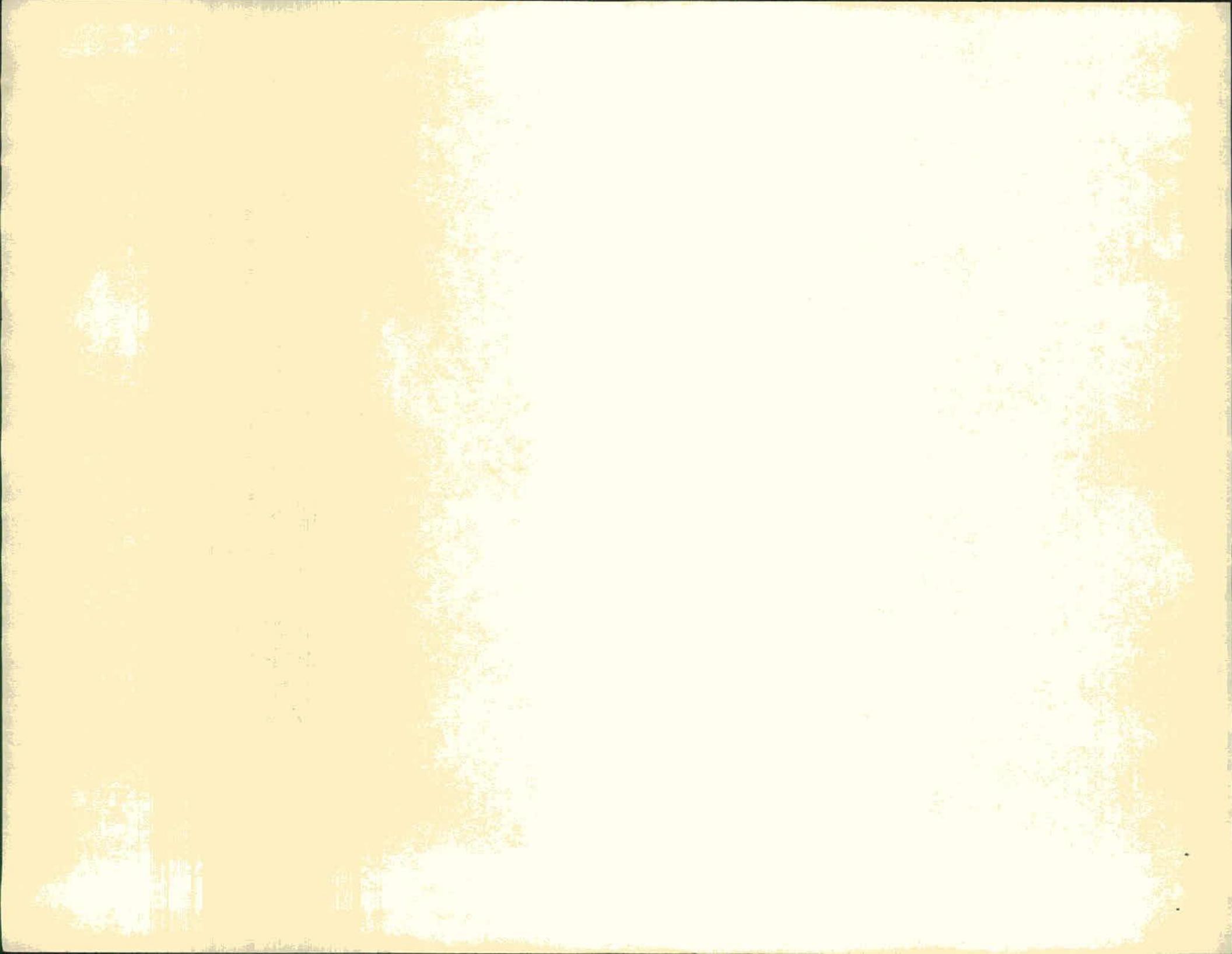
Comment: FINAL INSPECTION/W/O RELEASE

5/16/07/04

Job Completion

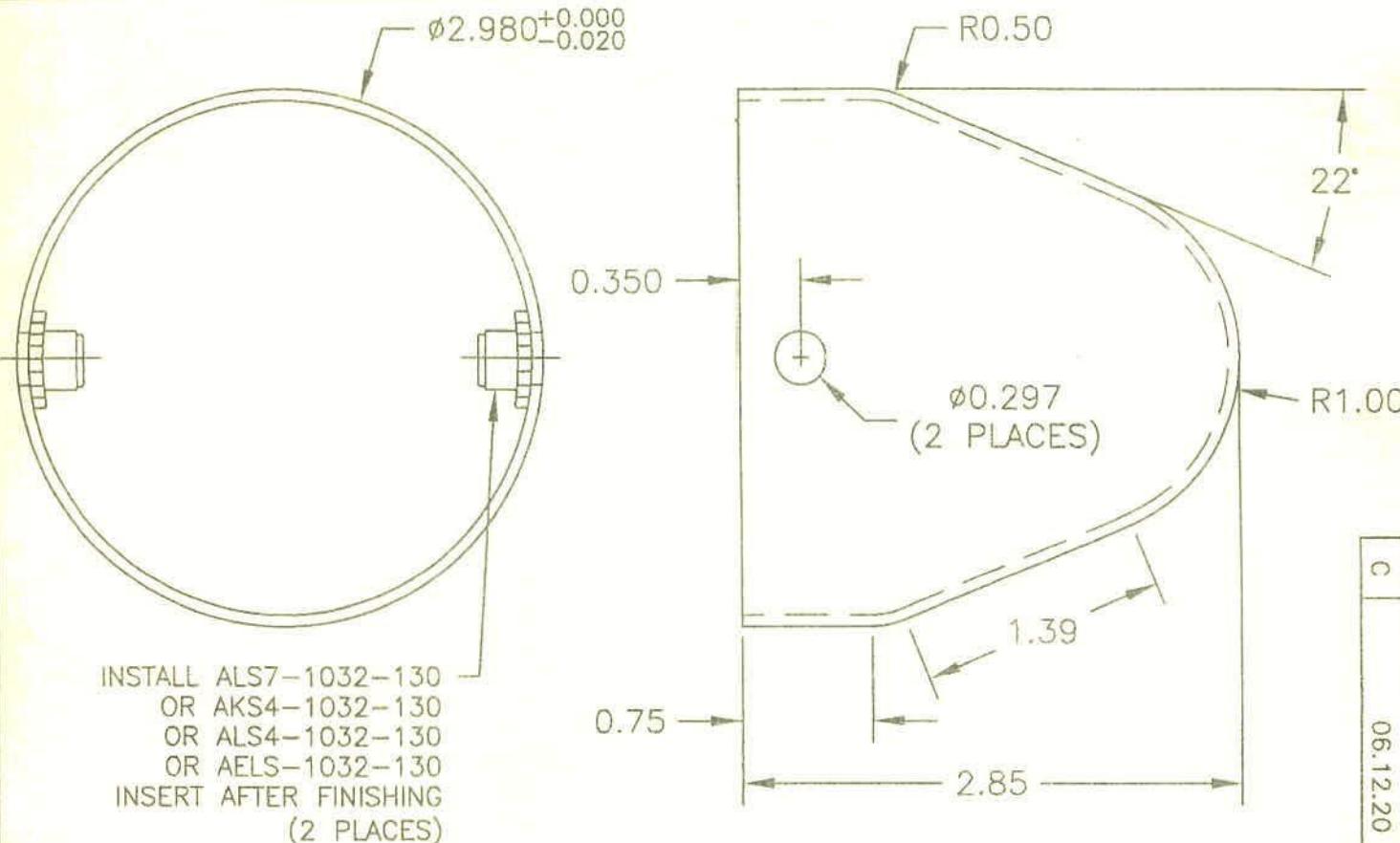


u 5/16/04



DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
DS	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2646
DATE	TITLE	REV. C SHEET 1 OF 1
06.12.20	AFT CAP	1:1 SCALE

**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

07-22-22
RELEASER

NO 32375
SUBJECT: AFT CAP
W/INS
DRAWN BY: PH
APPROVED BY: PH
CHECKED BY: PH



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO
COPPER & BRASS SALES INC
22355 WEST ELEVEN MILK ROAD
SOUTHFIELD, MI 48034

SHIPPED TO
COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9.760
PAGE 1 OF 1

ORDER NO	LB4176	PONO	C99792			MILO FINISH
ITEM NO	1	PART NO	050393-8			NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	COIL: STANDARD MILL FINISH
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH NON EMBOSSED

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.014	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI

TAIL ULTIMATE STRENGTH 12.6 KSI

HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI

TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI

HEAD ELONGATION (G.L. = 2 IN) 35.5 %

TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04

MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MERT THE REQUIREMENTS OF

ASME SB209 1100 O, AMS 4001H 1100 O

ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met these requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

REF ID: AYI, LAB SUPERVISOR

After Henry P. Clark
C/S
Joe L
UTS



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: June 4/07

Customer: Dart Aerospace

Packing Slip: 31273

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
B32375	16 ✓	1461100	N/A	✓	RR
B32427	50	1461100	N/A	✓	RR

Notes:

J

Material Certification Attached: Yes.

